

Tuesday, 28/08/2007 11:53:01 AM

Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2410
Job Number	: 34284	Part Number	: D2410
Estimate Number	: 10804	Drawing Number	: REWORK
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 28/08/2007	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Revision	: N/A
First Issue	: N/A	Material	: N/A
Previous Run	: 00015	Due Date	: 04/09/2007
Written By	:		
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 DISASSEMBLE D206-571-043 ASS'Y B/N 26886
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 disassemble D2410 assembly as follows: -remove D2403 outer skin -D2375-3-08-106 insulation -D2416 angle -D2411
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 -Pick 12x MS20600AD4W4 rivets B <u>H105792</u> (7a)
4.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP Inspect replaced rivets, as well as removed parts from the original assembly. *****Ensure no oversized holes*****

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Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

-Pick :

8x MS20600AD4W2 M M4747
2x MS20600AD4W3 M M18071
8x MS20470AD4-5 M M104156

- Reassemble D2410 as per Dwg D2410

FF 07-10-23

PTO

2

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
ensure all rivets are good

07/07/23 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
-Scuff WHITE AREA ONLY
- Re-powder coat as per dwg **** masking off the unpainted area's ****

M105069

(2)

BR 07-10-24

8.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

07-10-25 (2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
- Proceed with W/O D206-571-043 B 26886 for assembly.

FF 07-10-26

(2)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/29

Job Completion



07/10/29

9.5 QC21 S. 07/10/26
S. 07/10/26



PREPARED		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
B. Williams			
CHECKED	APPROVED	D2410	REV. A SHEET 1 OF 2
BW	BW		SCALE
DATE		TITLE	
Apr. 6, 1995		206 ASPIRATOR ASSEMBLY	
A	95.04.06	NEW ISSUE	
A1	RF 03.04.29	ADDED FLARE	

RELEASED
14-04-95 BW

QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS2060AD4-2	RIVET (CR 9163-4-2)
6	MS2060AD4-3	RIVET (CR 9163-4-3)
17	MS7060AD4-4	RIVET (CR 9163-4-4)
8	MS20470AD4-5	Rivets

REFERENCE ONLY

PREPARED	DART AERO ACCESSORIES INC		
VICTORIA INTERNATIONAL AIRPORT, CANADA			
checked	APPROVED	REV. A	
B.W.	B.W.	SHEET 2 OF 2	
DATE	SCALE		
Apr. 6, 1995			
D2410			
TITLE			
206 ASPIRATOR ASSEMBLY			

DART

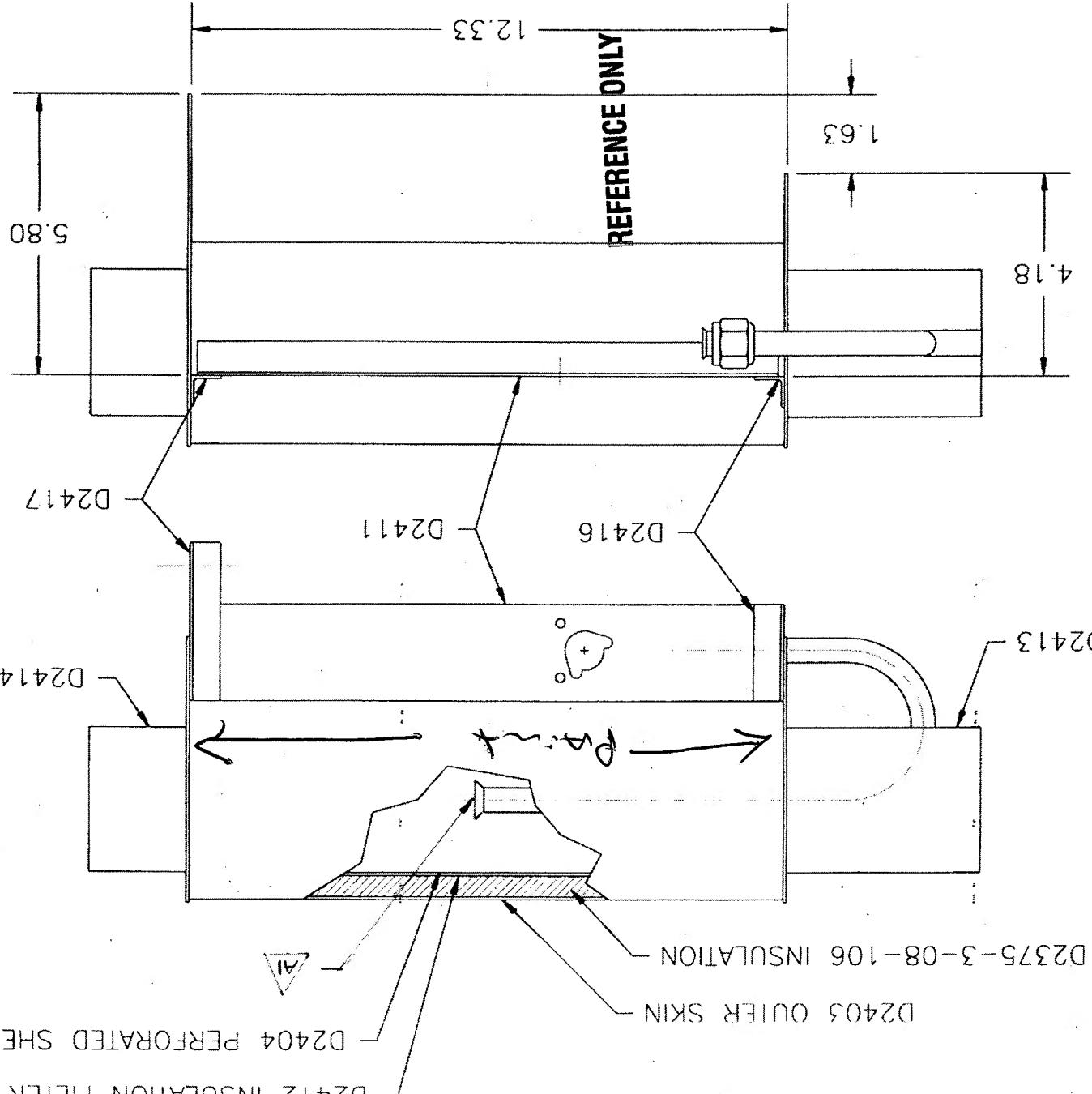
RELEASED
16/04/95 B.W.

D2412 INSULATION FILTER

D2404 PERFORATED SHEET

D2403 OUTIER SKIN

D2375-3-08-106 INSULATION



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/22	5	Replaced insulation on both heatshields. D 2375-3-08 (m10410)		Destroyed both insulation	FF 07/10/22			
07/10/22	5	Replaced ms 20600 AD4W3 with CR 32434-4 (m104252)	QSIU12			07-10-23	QSIU12	07-10-23
07/10/22	5	Replaced outer skin D 2403 with new one D 2403 (B 26904) 12 CR 32434-4 (m104252)	QSIU12	Destroyed old ones	FF 07/10/23	07-10-23	QSIU12	07-10-23
07-10-23	S.O	4 CR 3243-4-2 (m102601) PC! Champs dented material. The hole was oversized on the D2411. on 1 ASS'Y, when the rivet was removed. 1 more D2411 B24398 scrap	QSIU12	Replace D2411 B24398 Qty 1, and re-assemble.	B25066		QSIU12	07-10-23

NOTE: Date & initial all entries